

Work Order ID 108592

October-23-13 9:50:07 AM

D 2 4 3 2

108592

ASAP

Page 1

Item ID: D2432

B 108592

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: Bearpaw 19" X 24"

Start Date: 10/23/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 10/30/13 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: ML5Date: 13-10-23 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2432

H

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

GMMW 1" Black-Jm

20

0

JmB-10-23

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

20

0

JFL 2013-10-25

MH

13/10/26

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

MH

13/10/26

JFL 2013-10-25

Work Order ID 108592

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108592

Page 2

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 19" X 24"
 Start Date: 10/23/13 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/30/13 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

20 13-10-28

20x DAS 28 13-10-28

13-10-30
 ME
 13-10-29

Picklist Print

October-23-13 9:50:11 AM

Page 1

Work Order ID: 108592

108592

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 10/23/13

Required Date: 10/30/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	834.6282	3.7	74			

MUHMWB10

UHMW 1" Black

**

Jm 13-10-23

Location

Loc Qty

Loc Code

MAT019

834.6281795

121278

9.62817947

122575

47.6

123229

53

123704

63.8

123949

6.96

124382

197.12

124758

17.52

125137

199

m126748

240

126748

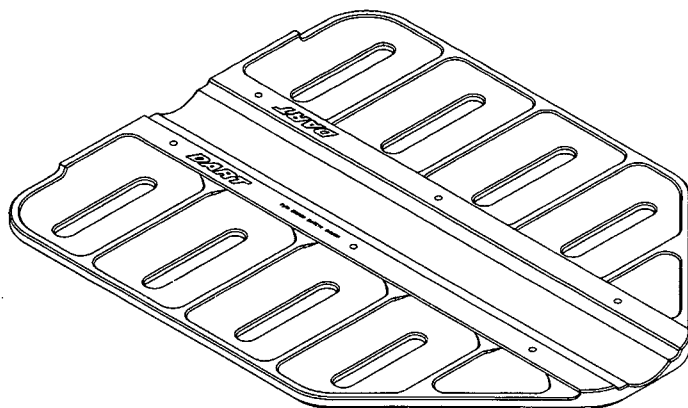
DART AEROSPACE LTD		Work Order: 108592
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: H		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

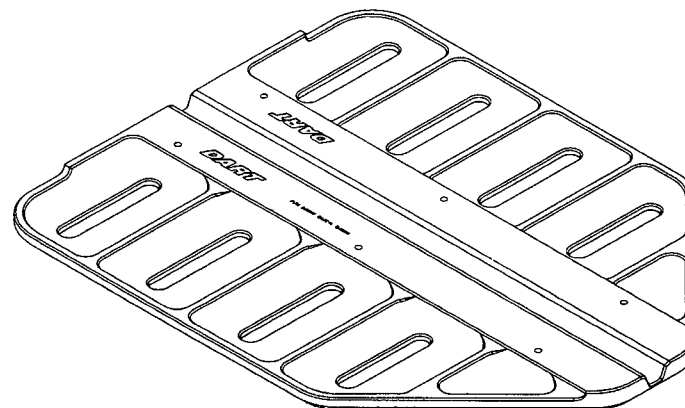
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	0.063	✓		depth G	JFC-07
5.500	+/-0.030	5.500	✓		Caliper	JFC-01
0.200	+/-0.030	0.203	✓		"	"
0.25 x 45°	+/-0.030	0.25 x 45°	✓		depth G	JFC-07
R0.250	+/-0.030	R0.250	✓		Rad G	Shop
0.250	+/-0.010	0.256	✓		Caliper	JFC-01
0.625	+/-0.030	0.624	✓		"	"
0.375	+/-0.010	0.377	✓		"	"
0.950	+0.030/0.010	0.964	✓		"	"
19.000	+/-0.030	19.00	✓		tape	JFC-06
3.14	+/-0.030	3.14	✓		Caliper	JFC-01
3.28	+/-0.030	3.28	✓		"	"
Ø0.260	+0.005/-0.000	0.260	✓		"	"
Ø0.93	+/-0.030	0.931	✓		"	"
0.30	+0.030/-0.000	0.308	✓		depth G	JFC-07
23.750	+/-0.030	23.750	✓		tape	JFC-06
4.250	+/-0.010	4.250	✓		Caliper	JFC-01
2.000	+/-0.030	2.001	✓		"	"
9.000	+/-0.010	9.000	✓		Caliper	CNC-02
9.000	+/-0.010	9.000	✓		"	"
0.375	+0.010	-	✓	-	Caliper	JFC-01
0.38	+0.031/-0.01	0.388	✓		"	"

Measured by: JFL	Audited by: SL	Preliminary Approval:
Date: 2013-10-25	Date: 10-28	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	



D2432F BEARPAW



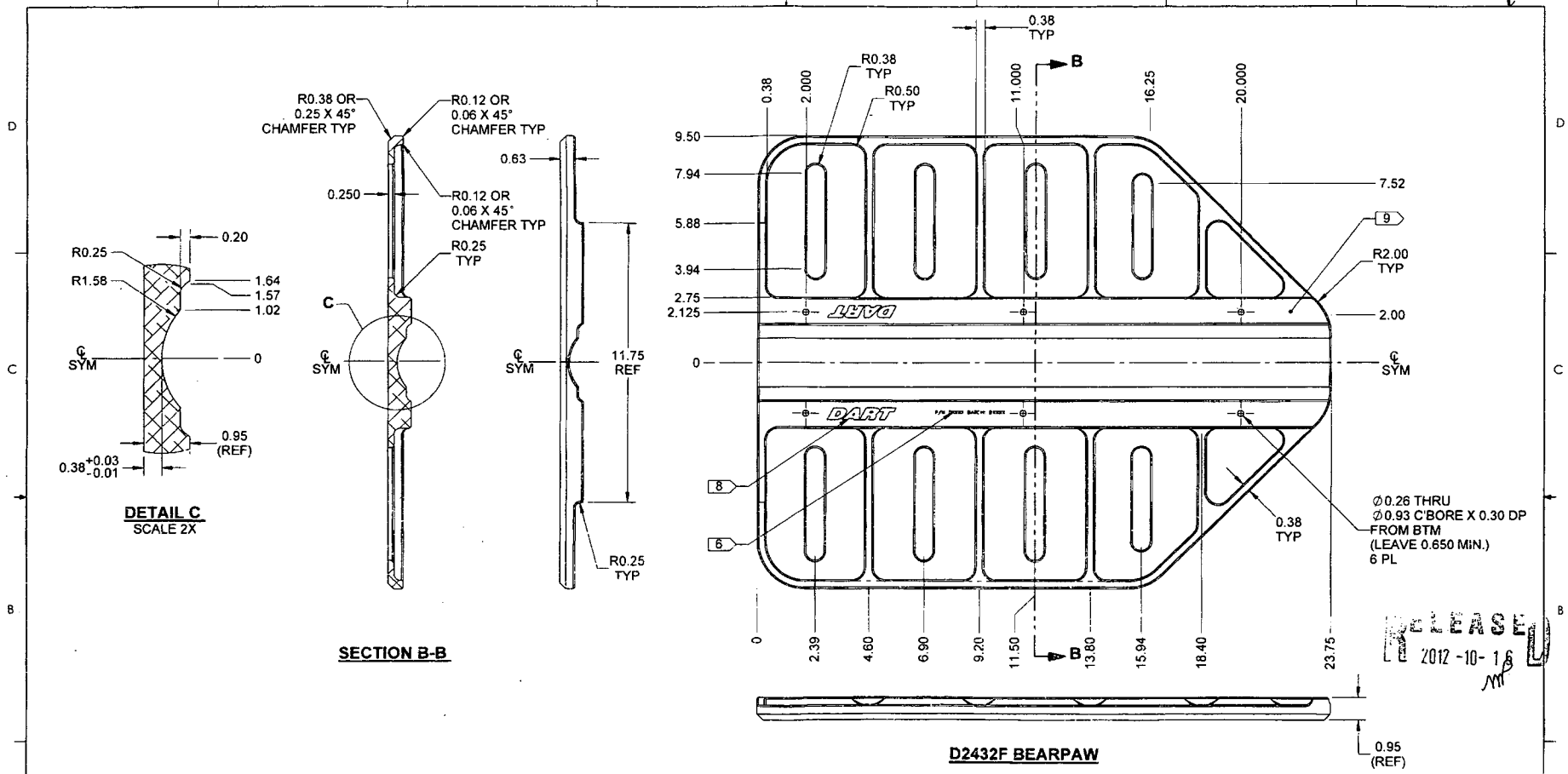
D2432-3 BEARPAW

RELEASED
2012-10-16

REV.	DESCRIPTION	BY	DATE
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	91	D2432	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	140	BEARPAW	NTS
DATE	12.09.24	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

108592
MCS
13-10-23

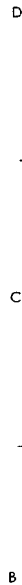
108592



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO. D2432	REV. H
MFG. APPR.	AT		SHEET 2 OF 3
APPROVED	AP	TITLE BEARPAW	SCALE NTS
DE APPR.	AT		
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[illegible]

D2432-3 BEARPAW

RECEIVED
2012-10-16

- A

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